

Date: Tuesday, 14/04/2009 1:22:10 PM
 User: Chantal Lavoie

Process Sheet

Sput

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MIRROR ASSEMBLY 8"
 Job Number : 47152 - 1
 Estimate Number : 11291
 P.O. Number :
 This Issue : 14/04/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run :
 Written By :
 Checked & Approved By : C 209/04/14
 Comment : Est. A05.07.20 New issue KJ/JLM

Part Number : D3439101
 Drawing Number : D3439 REV A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 21/04/2009 Qty: 5 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 8561
 For Grote Mirror P/N: 12183
 Possible Supplier: UAP/NAPA
 Material release note is required

C 209/04/14 (5)

2.0 12183 GROTE MIRROR



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 MIRROR

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage
 Ensure Material Release Note is attached

P 9/4/15 3

4.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Discard Hardware.
 Fabricate stud as per Dwg D3439
 Pick:

Qty Part Number Description Batch

1 5/16"-18UNCx1 1/4" Long Hex Bolt 40438 M 111463

(2)

Drill and Tap mirror as per Dwg D3439, then install stud.
 Coat threaded section of stud with LPS-3 before installing.

Pick:

Qty Part Number Description Batch

FF 09-04-27

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 14/04/2009 1:22:10 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ASSEMBLY 8"

Job Number: 47152

Part Number: D3439101

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/RN/A

LPS-3

1109929

Crimp stud as per Dwg D3439

FF 09-04-24 (2)

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

502/05/11 (2)

6.0

D30153

Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Lock Nut

Coat stud with LPS Procyon then install hardware loosely.

Pick:

Qty Part Number Description Batch

1 D3015-3 Lock nut

B45394

* 1 5/16WC Washer

1110138

A/R N/A LPS Procyon

1104251

FF 09-05-07 (2)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Plug drain holes with Sikaflex.

Ensure that mirror adheres to housing.

Pick:

Qty Part Number Description Batch

A/RN/A Sikaflex-241/-291

0012195438/0269

Sikaflex expiry date 01/20/10

FF 09-05-07 (2)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/05/11 (2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

51227

Regis (2)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 14/04/2009 1:22:10 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ASSEMBLY 8"

Job Number: 47152

Part Number: D3439101

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/11

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

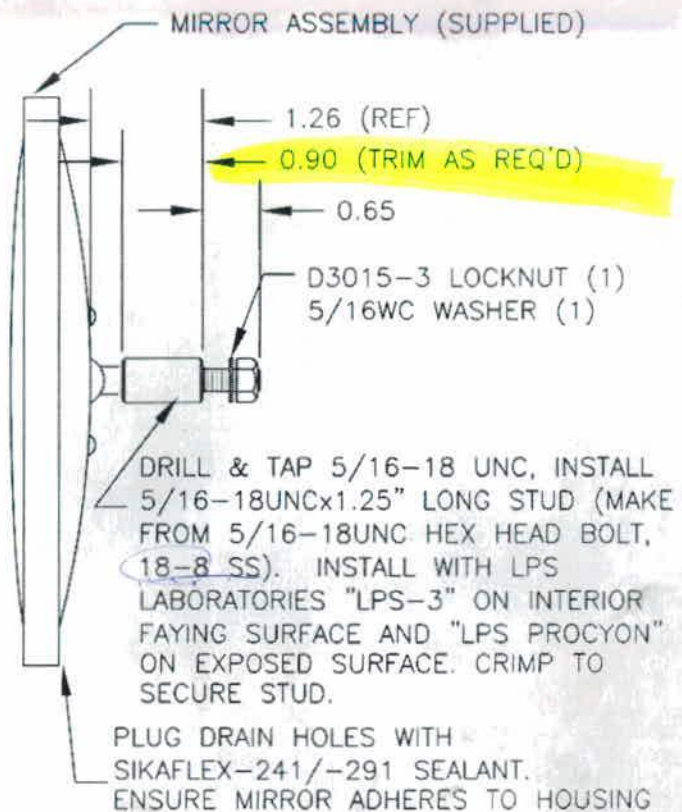
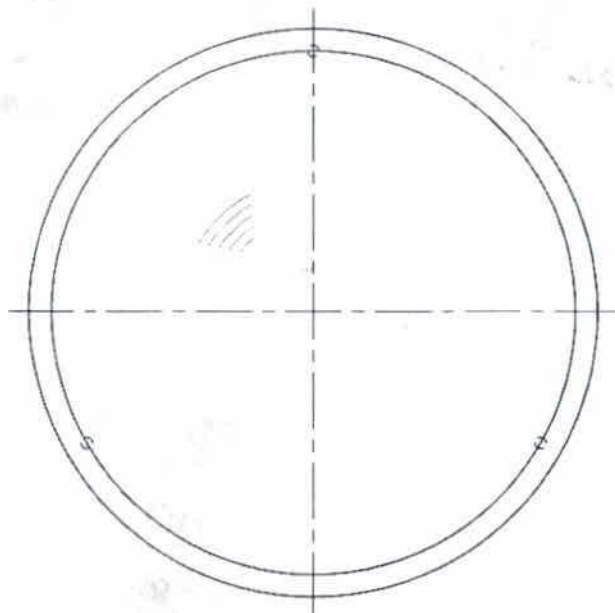
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO. D3439	REV. A SHEET 1 OF 1
DATE	05.05.27			TITLE MIRROR ASSEMBLY	SCALE NTS
A	05.05.27			NEW ISSUE	

RELEASED
05.05.27

QTY	Part Number	Description
-101		
X	D3439-101	MIRROR ASSEMBLY 8"
1	12183	MIRROR 8" (GROTE)
1	D3015-3	LOCKNUT
1	5/16WC	WASHER

NOTES:

1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

47152

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DART

Purchase Order

Date Apr 14, 2009	Page 1
Purchase Order Number PO00008561	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FXED
6/10/15

Vendor Address:

Acklands - Grainger Inc.
P.O. Box 2970
Winnipeg, Manitoba R3C 4B5
Canada
Phone (613) 632-2739
Fax (613) 632-5386

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-ACK001	Apr 14, 2009	N30	yours	Apr 16, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
✓ 5.0000 <i>New 3</i> <i>6/4/15</i>	12183	GROTE MIRROR Comments: AS PER DWG D3439 REV. A B47152 ACKLANDS P/N: GRO12183 <i>RUSH</i> CERTIFICATE OF CONFORMITY REQ'D UPON DELIVERY	16/04/2009	No	22.190000	Each	110.95

Comments:

Tax Summary:
GST
ONT PST

5.55
8.88

Less:
included tax

0.00

Subtotal

110.95

Total tax

14.43

Total purchase order in

CAD Dollars

125.38

Entered By: *CL* CLAVOIE

Approved By: _____

**ACKLANDS
GRAINGER**

ACKLANDS - GRAINGER INC.
765 CAMERON ST.
HAWKESBURY ON K6A 2B7
(613) 632-2739

REMIT
TO
EXPEDIEZ
A
SHIP
TO

ACKLANDS - GRAINGER INC.
PO BOX 2970
WINNIPEG MB R3C 4B5

DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY ON
K6A 1K7

PACKING SLIP ONLY
INVOICE TO FOLLOW

PACKING SLIP#
1417 0390204

1

PAGE
PAGE NO

1 of 1

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T
O

DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY ON
K6A 1K7

CLIENT CUST. NO. 1726280 NO. DE REFERENCE DU CLIENT CUST. REF. NO. 00008561 00008561
NO. DE LICENSE PROVINCIALE P.S.T. U.C. NO. 6122 5207 NO. DU CONTRAT CONTRACT NO. 00/00/0000 14:00
EXP. DIRECTE DIR. SHIP N DATE DE LA COMMANDE ORDER DATE 04/14/2009 DATE DE LA FACTURE INVOICE DATE 04/15/2009

TERMES TERMS *** NET 30 *** NO. DE VERSEMENTS NO. OF PMTS 0 M.E.P. M.B.P. 0 DATE DU PREMIER VERSEMENT FIRST PAYMENT DATE 00/00/0000 14:00
APP. DE CREDIT CREDIT AUTH S'APPLIQUE AU NO. DE FACTURE APPLY TO INVOICE N°/ R/C/ B.O./SUB COPIES T.P.S/GST

QUANTITE COMMANDEE QUANTITY ORDERED	QUANTITE EXPEDIEE QUANTITY SHIPPED	CODE DE COM. DIFF. B.O. CODE	DATE DE RECEPTION DE COMMANDE ORDERING DATE	PRIX PRICE PAR PER ESC DIS	PRIX EXTENSIONNE EXTENDED PRICE	T P S T
5	3	B	EA	19.033 1	57.10	YYY
GRO 12183 MIRROR CONVEX RND SS 8IN						
THEY NEED THOSE RUSH. ATN CHANTAL LAVOIE 613-632-9577						

GST# 88970-1272

SOUS TOTAL / SUB TOTAL

57.10

CLIENTSHIP VIA CUSTOMER PICK UP NO. D'ORDRE ORDER NO. PORT PAYE PPD FREIGHT DATE DE LIVRAISON REQUISE REQUESTED DELIVERY COMMANDEMENT BILL OF LADING CODE DE COM. DIFF. B.O. CODE 9275 9305 T.P.S./T.V.A. B.S.T./B.S.T. TAXE PROV. PROV. TAX 2.86 4.57

RECU
PAR
RECEIVED
BY

64.53

MONTANT TOTAL TOTAL AMOUNT

COPIE DU CLIENT
CUSTOMER COPY